

Date: Monday, 02/06/2008 4:32:22 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ARM
Job Number	: 39636A03		
Estimate Number	: 10145		
P.O. Number	:	Part Number	: D2037101
This Issue	: 02/06/2008 S.O. No. :	Drawing Number	: D2037 REV C3
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL / MED FAB	Drawing Revision	: C3
Previous Run	: 36919C	Material	:
Written By	:	Due Date	: 10/06/2008 Qty: 5 Um: Each
Checked & Approved By	: <u>JUD 08.6.02</u>		
Comment	: Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304TR0750W049	304 RD Tube .750 x .049W
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Comment: Qty.: 4.1118 f(s)/Unit Total : 20.5590 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
 Batch: M 107688

SJB 08/06/23

2.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SJB 08/06/23

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

Am 08/07/03
(5)

4.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

SJB 08/07/03
(5)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST241A

AS 08/07/04
(5)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: ARM

Job Number: 39636A03

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/07/08 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



U 08.07.07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

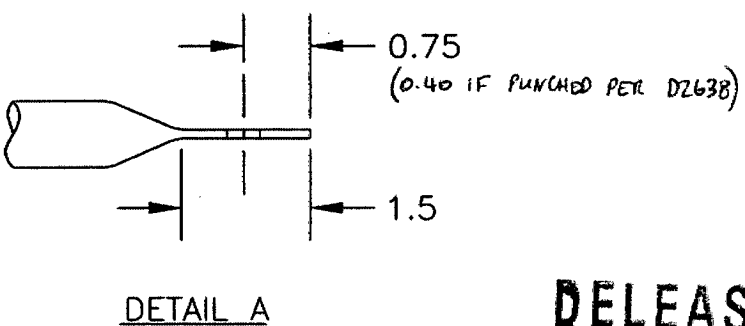
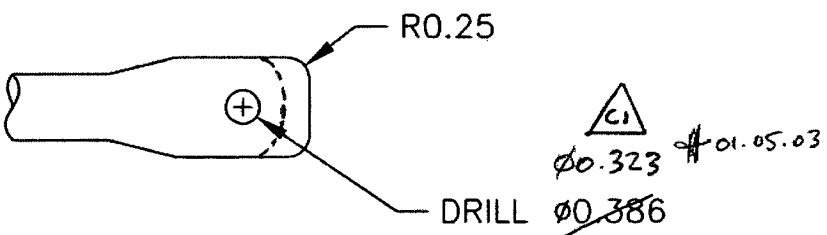
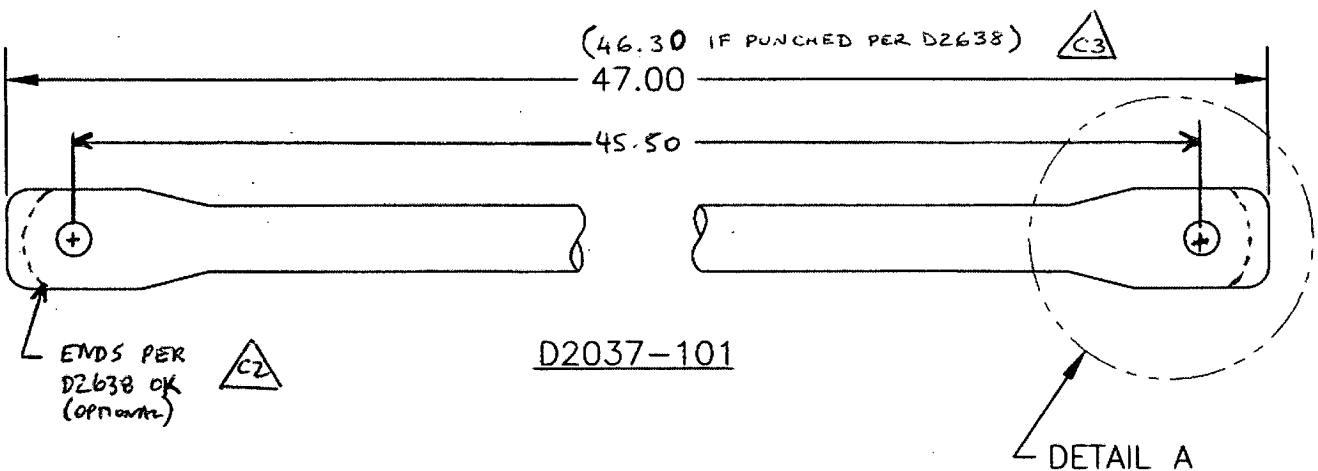
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NOTE: Date & initial all entries

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
JB	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
LE	[Signature]	D2037	
DATE	TITLE	SCALE	
99.06.07	ARM	NTS	
A	91.10.22	NEW ISSUE	
B	93.04.20	-103 DELETED	
C	99.06.07	REDRAWN, 0.386 WAS 0.375	
C1	01.05.03	CHANGE TO $\phi 0.323$	
C2	02.06.14	ADD PUNCH PER D2638 AS OPTION	



RELEASED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 391630-103

MATERIAL: AISI 304/316 SS SEAMLESS TUBE, 0.750 O.D. x 0.049 WAL